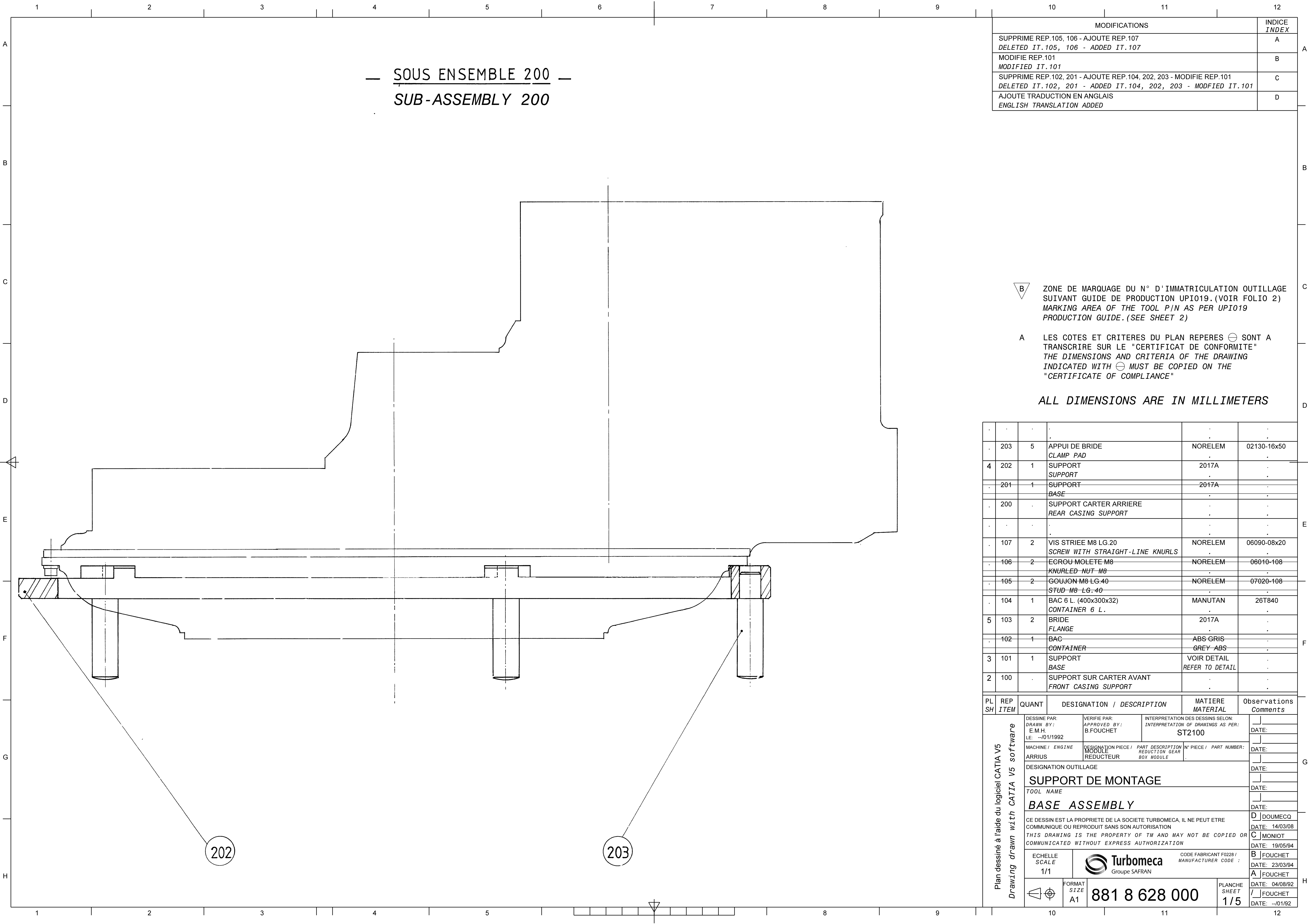


FICHE ARTICLE / *Product data sheet***(F0228)****8818628000****Version D****SUPPORT DE MONTAGE**



Version GEODE de l'Article / <i>Geode Part Version</i> :	D Engineering
Code OTAN fabricant / <i>Manufacturer NATO Code</i> :	F0228
Unité / <i>Unit</i> :	pièce
Vie limite / <i>Life limited part</i> :	Non
Sujet à péremption / <i>Subject to cure date</i> :	Non
Classification / <i>Classification</i> :	Catégorie 3 groupe 2
Durée limite de stockage (jours) / <i>Storage limit (days)</i> :	-1

DOCUMENTS DE REFERENCE / *Reference documents***ARTICLE DEFINI SELON LE DOCUMENT ST_02100 : Normes, d'application obligatoire pour l'interprétation des dessins TURBOMECA**




MODIFICATIONS		INDICE INDEX
SUPPRIME REP.105, 106 - AJOUTE REP.107 DELETED IT.105, 106 - ADDED IT.107		A
MODIFIE REP.101 MODIFIED IT.101		B
SUPPRIME REP.102, 201 - AJOUTE REP.104, 202, 203 - MODIFIE REP.101 DELETED IT.102, 201 - ADDED IT.104, 202, 203 - MODIFIED IT.101		C
AJOUTE TRADUCTION EN ANGLAIS ENGLISH TRANSLATION ADDED		D

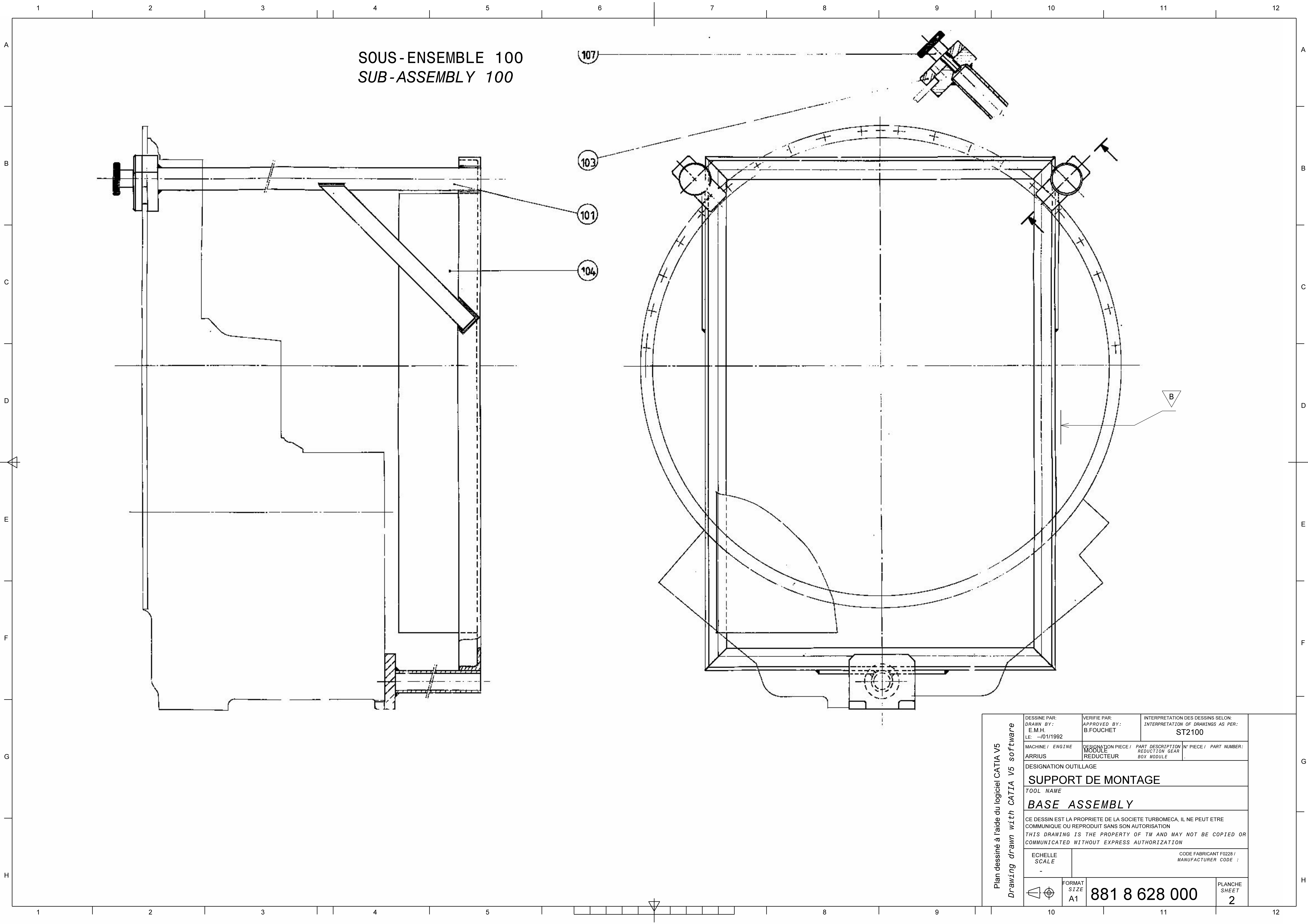
B ZONE DE MARQUAGE DU N° D'IMMATRICULATION OUTILLAGE
SUIVANT GUIDE DE PRODUCTION UPI019.(VOIR FOLIO 2)
MARKING AREA OF THE TOOL P/N AS PER UPI019
PRODUCTION GUIDE.(SEE SHEET 2)

A LES COTES ET CRITERES DU PLAN REPERES  SONT A
TRANSCRIRE SUR LE "CERTIFICAT DE CONFORMITE"
THE DIMENSIONS AND CRITERIA OF THE DRAWING
INDICATED WITH  MUST BE COPIED ON THE
"CERTIFICATE OF COMPLIANCE"

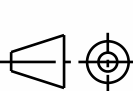
ALL DIMENSIONS ARE IN MILLIMETERS

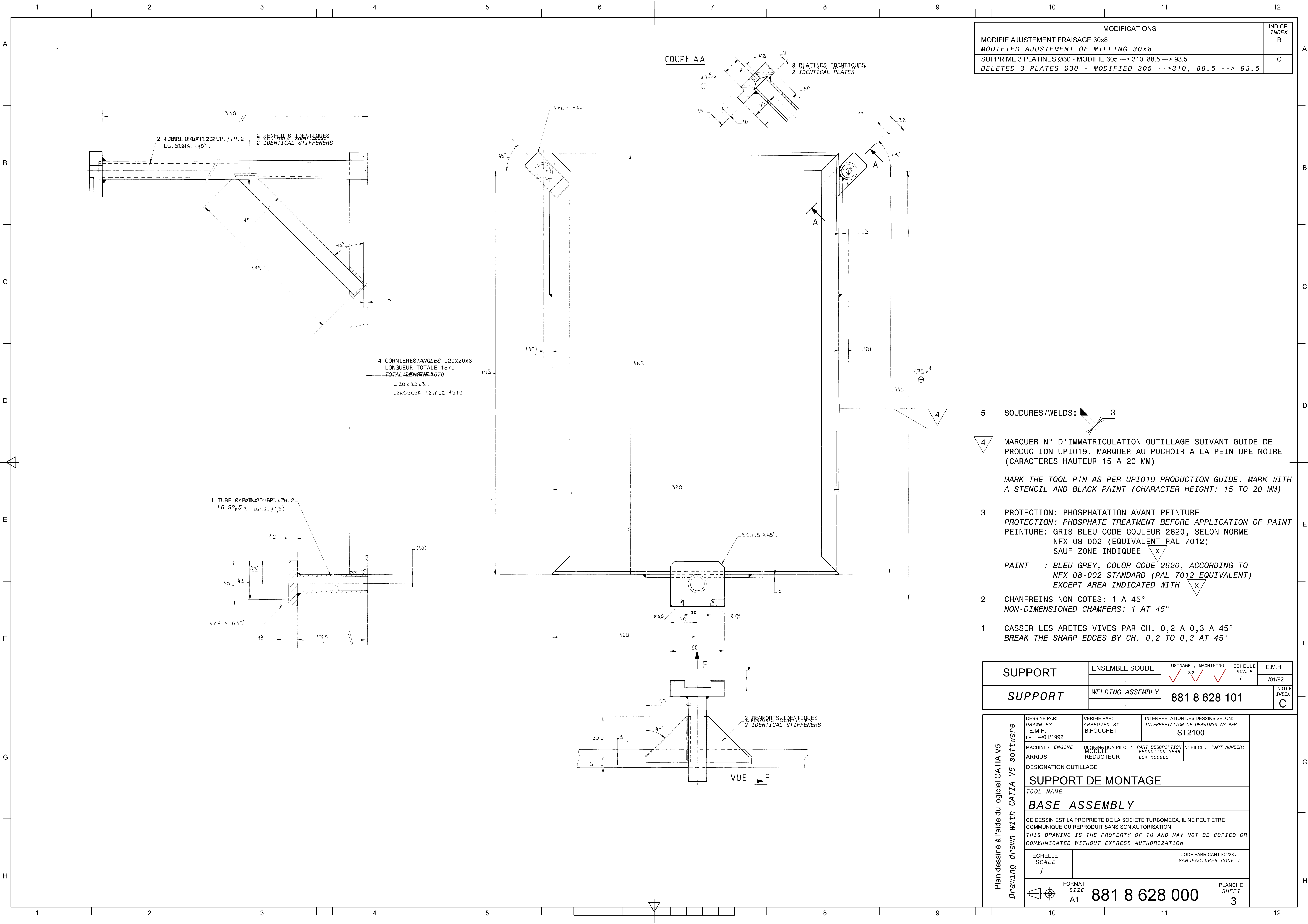
.
.	203	5	APPUI DE BRIDE CLAMP PAD	NORELEM	02130-16x50
4	202	1	SUPPORT SUPPORT	2017A	.
.	201	1	SUPPORT BASE	2017A	.
.	200	.	SUPPORT CARTER ARRIERE REAR CASING SUPPORT	.	.
.
.	107	2	VIS STRIEE M8 LG.20 SCREW WITH STRAIGHT-LINE KNURLS	NORELEM	06090-08x20
.	106	2	ECROU-MOLETE M8 KNURLED NUT-M8	NORELEM	06010-108
.	105	2	GOIJON M8 LG.40 STUD-M8 LG.40	NORELEM	07020-108
.	104	1	BAC 6 L. (400x300x32) CONTAINER 6 L.	MANUTAN	26T840
5	103	2	BRIDE FLANGE	2017A	.
.	102	1	BAC CONTAINER	ABS GRIS GREY ABS	.
3	101	1	SUPPORT BASE	VOIR DETAIL REFER TO DETAIL	.
2	100	.	SUPPORT SUR CARTER AVANT FRONT CASING SUPPORT	.	.

PL SH	REP ITEM	QUANT	DESIGNATION / DESCRIPTION	MATIERE MATERIAL	Observations Comments
Plan dessiné à l'aide du logiciel CATIA V5 Drawing drawn with CATIA V5 software			DESSINE PAR: DRAWN BY: E.M.H. LE: --/01/1992	VERIFIE PAR: APPROVED BY: B.FOUCHET	INTERPRETATION DES DESSINS SELON: INTERPRETATION OF DRAWINGS AS PER: ST2100
			MACHINE / ENGINE MODULE ARRIUS	DESIGNATION PIECE / PART DESCRIPTION REDUCTION GEAR REDUCTEUR	N° PIECE / PART NUMBER: .
			DESIGNATION OUTILLAGE TOOL NAME		
			SUPPORT DE MONTAGE BASE ASSEMBLY		
			CE DESSIN EST LA PROPRIETE DE LA SOCIETE TURBOMECA, IL NE PEUT ETRE COMMUNIQUE OU REPRODUIT SANS SON AUTORISATION THIS DRAWING IS THE PROPERTY OF TM AND MAY NOT BE COPIED OR COMMUNICATED WITHOUT EXPRESS AUTHORIZATION		
			ECHELLE SCALE 1/1	 Turbomeca Groupe SAFRAN	CODE FABRICANT F0228 / MANUFACTURER CODE : B FOUCHET A FOUCHET
			FORMAT SIZE A1	881 8 628 000	PLANCHE SHEET 1/5

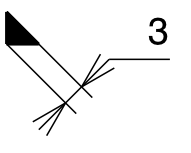

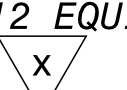


Plan dessiné à l'aide du logiciel CATIA V5
Drawing drawn with CATIA V5 software

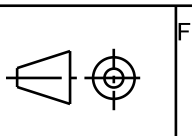
DESSINE PAR: DRAWN BY: E.M.H. LE: --/01/1992		VERIFIE PAR: APPROVED BY: B.FOUCHET		INTERPRETATION DES DESSINS SELON: INTERPRETATION OF DRAWINGS AS PER: ST2100	
MACHINE / ENGINE ARRIUS		DESIGNATION PIECE / MODULE REDUCTEUR		N° PIECE / PART NUMBER: BOX MODULE	
DESIGNATION OUTILLAGE					
SUPPORT DE MONTAGE					
TOOL NAME					
BASE ASSEMBLY					
CE DESSIN EST LA PROPRIETE DE LA SOCIETE TURBOMECA, IL NE PEUT ETRE COMMUNIQUE OU REPRODUIT SANS SON AUTORISATION THIS DRAWING IS THE PROPERTY OF TM AND MAY NOT BE COPIED OR COMMUNICATED WITHOUT EXPRESS AUTHORIZATION					
ECHELLE SCALE -		CODE FABRICANT F0228 / MANUFACTURER CODE :			
		FORMAT SIZE A1		881 8 628 000	
				PLANCHE SHEET 2	

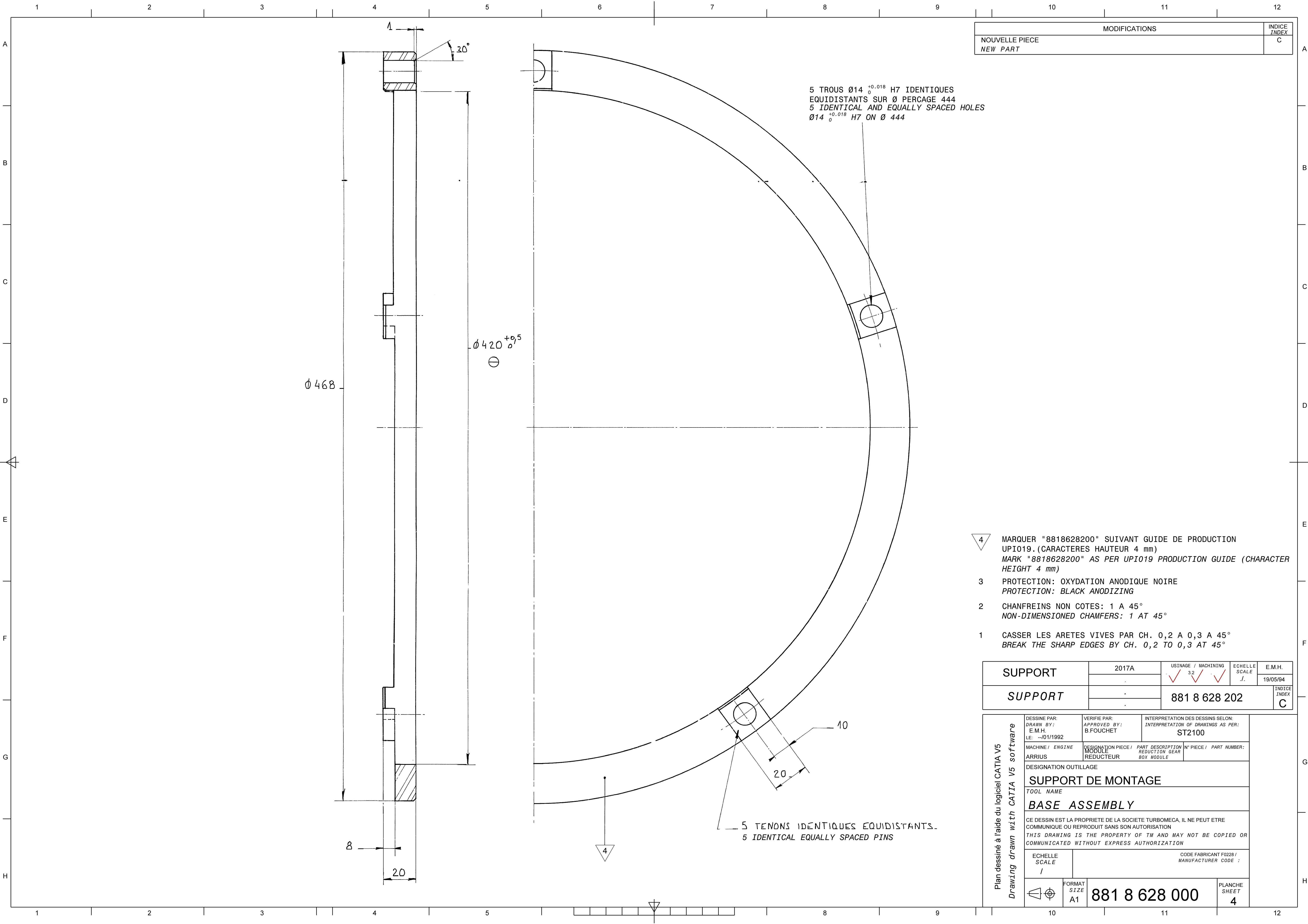


MODIFICATIONS	INDICE INDEX
MODIFIE AJUSTEMENT FRAISAGE 30x8 MODIFIED AJUSTEMENT OF MILLING 30x8	B
SUPPRIME 3 PLATINES Ø30 - MODIFIE 305 ----> 310, 88.5 ----> 93.5 DELETED 3 PLATES Ø30 - MODIFIED 305 -->310, 88.5 --> 93.5	C

- 5 SOUDURES/WELDS: 
- 4 MARQUER N° D'IMMATRICULATION OUTILLAGE SUIVANT GUIDE DE PRODUCTION UPI019. MARQUER AU POCHOIR A LA PEINTURE NOIRE (CARACTERES HAUTEUR 15 A 20 MM)
MARK THE TOOL P/N AS PER UPI019 PRODUCTION GUIDE. MARK WITH A STENCIL AND BLACK PAINT (CHARACTER HEIGHT: 15 TO 20 MM)
- 3 PROTECTION: PHOSPHATATION AVANT PEINTURE
PROTECTION: PHOSPHATE TREATMENT BEFORE APPLICATION OF PAINT
PEINTURE: GRIS BLEU CODE COULEUR 2620, SELON NORME NFX 08-002 (EQUIVALENT RAL 7012)
SAUF ZONE INDIQUEE 
PAINT : BLEU GREY, COLOR CODE 2620, ACCORDING TO NFX 08-002 STANDARD (RAL 7012 EQUIVALENT) EXCEPT AREA INDICATED WITH 
- 2 CHANFREINS NON COTES: 1 A 45°
NON-DIMENSIONED CHAMFERS: 1 AT 45°
- 1 CASSER LES ARETES VIVES PAR CH. 0,2 A 0,3 A 45°
BREAK THE SHARP EDGES BY CH. 0,2 TO 0,3 AT 45°

SUPPORT	ENSEMBLE SOUDE	USINAGE / MACHINING 3.2 ✓✓✓	ECHELLE SCALE /	E.M.H. --/01/92
SUPPORT	WELDING ASSEMBLY	881 8 628 101		INDICE INDEX C

Plan dessiné à l'aide du logiciel CATIA V5 Drawing drawn with CATIA V5 software	DESSINE PAR: DRAWN BY: E.M.H. LE: --/01/1992	VERIFIE PAR: APPROVED BY: B.FOUCHET	INTERPRETATION DES DESSINS SELON: INTERPRETATION OF DRAWINGS AS PER: ST2100	
	MACHINE / ENGINE ARRIUS	DENOMINATION PIECE / PART DESCRIPTION REDUCTEUR	MODULE REDUCTEUR	N° PIECE / PART NUMBER:
	DESIGNATION OUTILLAGE SUPPORT DE MONTAGE			
	TOOL NAME BASE ASSEMBLY			
	CE DESSIN EST LA PROPRIETE DE LA SOCIETE TURBOMECA. IL NE PEUT ETRE COMMUNIQUE OU REPRODUIT SANS SON AUTORISATION THIS DRAWING IS THE PROPERTY OF TM AND MAY NOT BE COPIED OR COMMUNICATED WITHOUT EXPRESS AUTHORIZATION			
ECHELLE SCALE /		CODE FABRICANT F0228 / MANUFACTURER CODE :		
	FORMAT SIZE A1	881 8 628 000		PLANCHE SHEET 3



MODIFICATIONS		INDICE INDEX
NOUVELLE PIECE NEW PART		C

5 TROUS Ø14 ^{+0.018}₀ H7 IDENTIQUES
EQUIDISTANTS SUR Ø PERCAGE 444
5 IDENTICAL AND EQUALLY SPACED HOLES
Ø14 ^{+0.018}₀ H7 ON Ø 444

Ø 420 ^{+0.5}₀

Ø 468

- 4 MARQUER "8818628200" SUIVANT GUIDE DE PRODUCTION
UPI019. (CARACTERES HAUTEUR 4 mm)
MARK "8818628200" AS PER UPI019 PRODUCTION GUIDE (CHARACTER
HEIGHT 4 mm)
- 3 PROTECTION: OXYDATION ANODIQUE NOIRE
PROTECTION: BLACK ANODIZING
- 2 CHANFREINS NON COTES: 1 A 45°
NON-DIMENSIONED CHAMFERS: 1 AT 45°
- 1 CASSER LES ARETES VIVES PAR CH. 0,2 A 0,3 A 45°
BREAK THE SHARP EDGES BY CH. 0,2 TO 0,3 AT 45°

SUPPORT	2017A	USINAGE / MACHINING ✓ 3.2 ✓ ✓	ECHELLE SCALE /.	E.M.H. 19/05/94
	SUPPORT			INDICE INDEX C
		881 8 628 202		

Plan dessiné à l'aide du logiciel CATIA V5 Drawing drawn with CATIA V5 software	DESSINE PAR: DRAWN BY: E.M.H. LE: --/01/1992	VERIFIE PAR: APPROVED BY: B.FOUCHET	INTERPRETATION DES DESSINS SELON: INTERPRETATION OF DRAWINGS AS PER: ST2100	
	MACHINE / ENGINE ARRIUS	DESIGNATION PIECE / MODULE REDUCTEUR	PART DESCRIPTION REDUCTION GEAR BOX MODULE	N° PIECE / PART NUMBER:
	DESIGNATION OUTILLAGE TOOL NAME			
	SUPPORT DE MONTAGE BASE ASSEMBLY			
	CE DESSIN EST LA PROPRIETE DE LA SOCIETE TURBOMECA. IL NE PEUT ETRE COMMUNIQUE OU REPRODUIT SANS SON AUTORISATION THIS DRAWING IS THE PROPERTY OF TM AND MAY NOT BE COPIED OR COMMUNICATED WITHOUT EXPRESS AUTHORIZATION			
	ECHELLE SCALE /	CODE FABRICANT F0228 / MANUFACTURER CODE :		
FORMAT SIZE A1		881 8 628 000		PLANCHE SHEET 4

